

SPLIT-1

DART AEROSPACE LTD	Work Order:	24609
Description: Saddle billet	Part Number:	D6101-005
Drawing: D6101 Rev. A	Qty:	100

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	U	050812	100
2	PURCHASING	Issue P/O: <u>2008471</u> a) Description: Alluminum billet b) 5.00" x 8.250" x 2.50" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 5.00" length e) Material: 7075-T7351 (QQ-A-250/12) <b>Material certification required</b>	U	0508.12	100
3	RECEIVING	Receive & Inspect for transit damage <b>Ensure certification are attached</b>	CL	06/02/01	50
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	ML	06/02/15	50
5	STORES	Identify & stock	CL	06/02/01	50
6	EXPEDITING	Close W/O Cost / part <u>345 06/02/16</u> <sup>Inspect</sup> <u>50</u> Level 21	D	06/02/16	50

Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

EC 01.05.16

RF  
03.06.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 06/02/16

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

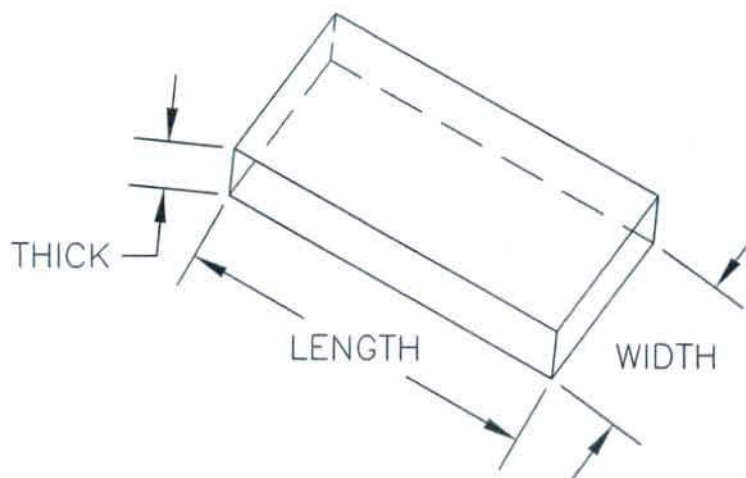




DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED [Signature]	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
01.04.23 [Signature]



SHOP COPY  
RETURN TO  
ENGINEER  
UNCONTROLLED  
SUBJECT TO  
WITHOUT NOTICE  
WORK ORDER  
NO. 2406A

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 12, 2005  
11:19 am

Work Order No	: 0024069	Department Code:	
Project Name	: D6101-005	Burden Flags	: NNNNNNN
Project For	: WK540	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6101-005	Invoice Number	:
Description	: 7075-T7351 8.25X5.0X2.5	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 100	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-12-05		
Est Finish Date	: 10-01-05		
Act Finish Date	:	Est Margin	: 0.000%
Drawings Req'd	: No	Actual Margin	: 0.000%
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



# PECHINEY ROLLED PRODUCTS

## CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164 USA

COPPER & BRASS SALES, INC.  
5 STERLING DRIVE  
WALLINGFORD CT

06492

COPPER AND BRASS SALES  
P.O. BOX 5116  
SOUTHFIELD MI

48086

COPPER&BR

C71206 1512

INCLUSION

SERIAL#: 20051228C71206

1

CUSTOMER PURCHASE ORDER NO. & ITEM <b>CF3076</b>				PECHINEY ORDER NO. <b>235-304343</b>	
ALLOY <b>7075</b>	CLAD. <b>00</b>	TEMPER <b>T7351</b>	GAUGE <b>2.50000</b>	WIDTH <b>48.500</b>	LENGTH <b>144.500</b>
ITEM ORDERED <b>MOLD PLATE-DIST GE SPEC PLATE, SAWED MILL</b>					
CUSTOMER SPECIFICATION <b>AMS-QQ-A-250/12</b>					
PART NUMBER <b>091557-9</b>			B/L NUMBER <b>C71200</b>		DATE SHIPPED <b>12/29/05</b>
WEIGHT SHIPPED <b>3,630</b>		NO. OF PIECES <b>2</b>		GOVT. CONTRACT NO.	

**CERTIFICATION**  
"Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

PECHINEY ROLLED PRODUCTS

P.O. BOX 68

RAVENSWOOD, WV 26164 USA

*Ladonna B. Smith*  
LADONNA B. SMITH - LABORATORY MANAGER

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IAC										
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN	MAX									
496951	LT	2	***** T7351 70.3	70.3	58.5	58.7	***** 11.5	12.0	39.5	39.9									
-----																			
ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS																			
-----																			
MIL-STD-2154 100%SONIC TESTED MINUS DEAD ZONE CLASS A																			
ALSO CONFORMS TO BSS 7055 CL A SONIC																			
ALSO CONFORMS TO MMS159J. ASTM B209-04, AMS 4078E																			
C. H.E.M.  C.O.M.P.	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
		SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																			





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RAVENSWOOD, WV 26164 USA

COPPER & BRASS SALES, INC.  
5 STERLING DRIVE  
WALLINGFORD CT

COPPER AND BRASS SALES  
P.O. BOX 5116  
SOUTHFIELD MI

06492

48086

COPPER&BR

C71206 1512

INCLUSION

SERIAL#: 20051228C71206

2

CUSTOMER PURCHASE ORDER NO. & ITEM <b>CF3076</b>				PECHINEY ORDER NO. <b>235-304343</b>	
ALLOY <b>7075</b>	CLAD <b>00</b>	TEMPER <b>T7351</b>	GAUGE <b>2.50000</b>	WIDTH <b>48.500</b>	LENGTH <b>144.500</b>
ITEM ORDERED <b>MOLD PLATE-DIST GE SPEC PLATE, SAWED MILL</b>					
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PART NUMBER <b>091557-9</b>			B/L NUMBER <b>C71200</b>		DATE SHIPPED <b>12/29/05</b>
WEIGHT SHIPPED <b>3,630</b>		NO. OF PIECES <b>2</b>		GOVT. CONTRACT NO.	

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P.O. BOX 68

RAVENSWOOD, WV 26164 USA

*LaDonna B. Smith*  
LADONNA B. SMITH - LABORATORY MANAGER

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IAC										
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN	MAX									
496951			ACTUAL CHEMICAL COMPOSITION																
SI=0.07 FE=0.16 CU= 1.5 MN=0.06 MG= 2.6 CR=0.18 ZN= 5.5 TI=0.03																			
OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																			
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTE APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE.																			
THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.																			
CHEMISTRY BY OES: ARKSPARK																			
CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT.																			
WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399.																			
WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557.																			
"END OF CERTIFICATION"																			
CHEM COMP	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
		SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																			

